

Work Order ID 148015

June 17, 2016 1:09:53 PM

148015

Page 1

Item ID: D3709-1

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Angle

Stop

NS2

Start Date: 6/17/2016

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/20/2016

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date: 6/17/16

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3709

Rev A

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.08

FLOW CNC Waterjet

1-Cut as per Dwg D3709

Dwg Rev: A

Prog Rev: A

****grain direction on a 45 degree ****

2- DEBURR BY HAND ONLY

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

PR 16/06/17

10

10

PR 2016/06/17

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Item ID: D3709-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Angle

Start Date: 6/17/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
Hand Finish	Memo	0.07							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.03							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST235</u>	0.00							
170									
Packaging	Memo	0.02							
Packaging									

(8)

226/08/11
BEB

(8)

DAS
38
9-89
AUG 11 2016

Cont
(8)

NC

AUG 11 2016

2m 16/08/12

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Item ID: D3709-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 6/17/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.17

Quality Control

AUG 11 2016

S/A

Picklist Print

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Work Order ID: 148015

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Parent Item: D3709-1

D3709-1

Parent Item Name: Angle

Start Date: 6/17/2016

Required Date: 6/20/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-10-31 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No			sf	724.9000		2.8			

M6061T6S 063

6061-T6 .063 Sheet

Pl 2016/06/17

Location

Loc Qty

Loc Code

MAT021

388.9

M133511

2.6

M134377

3.3

M134830

383

TPI

336

M134496

192

M134604

144

3.1

D3709-3 ANGLE

D3709-1 ANGLE

RELEASED
29/04/1987

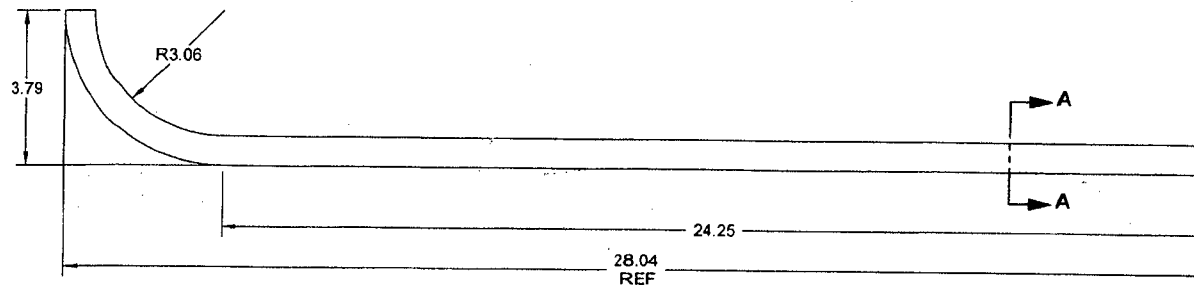
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3709-1 = 0.24 lbs
D3709-3 = 0.16 lbs

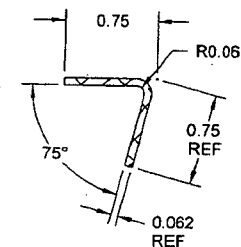
A	NEW ISSUE	MB	08.05.02
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.02		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3709	REV. A
TITLE ANGLE	SHEET 1 OF 3
SCALE NTS	

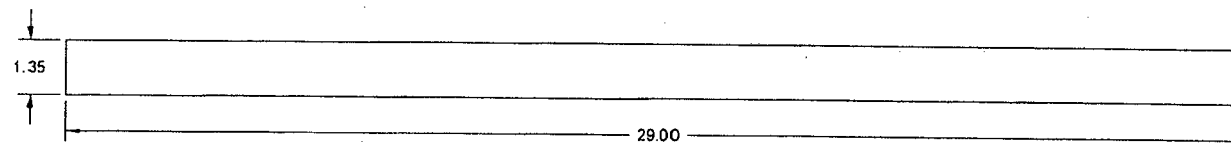
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D3709-1 ANGLE
(MAKE FROM D3709-1F)



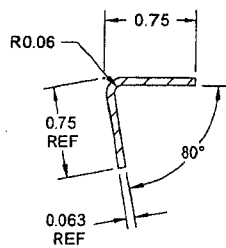
SECTION A-A
SCALE 2X



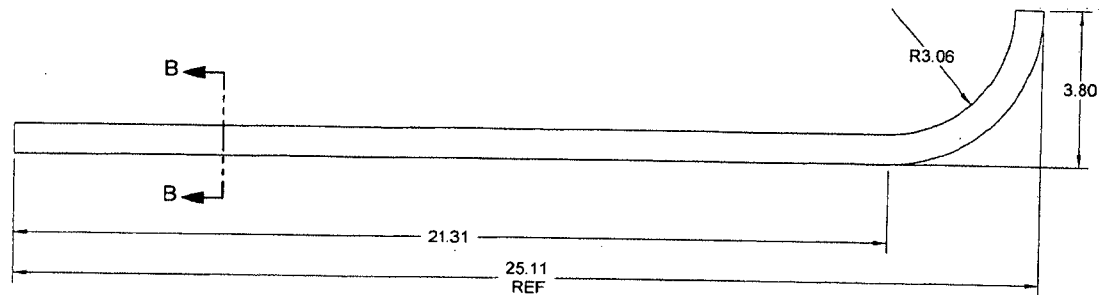
D3709-1F ANGLE FLAT PATTERN

RELEASED
09/04/01

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DE APPR.		ANGLE	NTS
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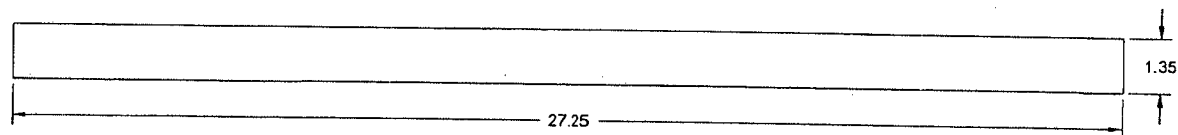


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

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09/04/09

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